Work Orde Tuesday, May 18											Page
Revision ID:	D4016-1 Hinge Half, E	Base		Accept					Setup Sta Sto		
Start Date: Required Date: Reference:	5/18/2010 5/31/2010	Start Qty: 9.00 Req'd Qty: 9.00		·	Cust Item I Customer:	D;				I IIIIIII	: ::::::::::::::::::::::::::::::::::::
Approvals:	Process Pla	an:	Date:	FTooling: SPC (Y/N):		ıte:			Run Sta Sto	1 (88)))8) 8	
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr		·							
D4016	A			*							
100 Bandsaw		Cut blanks as per folio Memo		0.00 0.00 Arf	10/05/22			9	ø		
Jeaspa Bandsaw		CUT BLAN	K 1.00" LONG								

110 HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

DEBURR

Dart Aerospace Ltd	Dart	Aer	osi	pace	Ltd
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W/O:			V	VORK OR	DER CHANG	ES		nes.			
DATE	STEP	PRO	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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											·
Part No	:	PAR #:	Fault Ca	itegory:		_ NCR:	Yes 1	lo DQ	A:	_ Date: _	
		esolution:									
NCR:			WORK OR	DER NON-	CONFORM	ANCE (NCR)).			
DATE STEP		Description of NC	Corrective Action Section					Verific	ation	Approval	Approval
	0.2.	Section A	Initial Chief Eng				Sign & Date		on C	Chief Eng	QC Inspector
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										•	

Work Order ID 58745

Tuesday, May 18, 2010 10:17:11 AM



Page 2

Item ID:

D4016-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Hinge Half, Base

Required Date: 5/31/2010

Start Date:

5/18/2010

QC:

Start Otv: 9.00

Req'd Qty: 9.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____

Date:_____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

120

Operation **Description**

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours**

0.00

Draw Number

Plan Draw Rev. Code

Accept Qty

Reject Oty

Reject Number

Insp. Stamp

Quality Control

Date:

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

160

Packaging

Identify as per dwg & Stock Location: Deskot

0.00

Memo

Packaging

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	GES				
DATE STEP PROCEDURE CHANGE				ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA	\ :	Date:	
		solution:							
NCR:		\	NORK ORD	ER NON-CONFORM	ANCE (NCF	R).			
DATE	STEP	Description of NC	1		tion B	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
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							' 1		

Work Order ID 58745

Tuesday, May 18, 2010 10:17:11 AM



Page 3

Item ID:

D4016-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Hinge Half, Base

Start Date: 5/18/2010 Required Date: 5/31/2010

Start Qty: 9.00

Req'd Oty: 9.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

Date:___

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

170

Description

Operation

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

...,1

0.00

Draw Plan Reject Accept Rev. Qty Code Qty

Reject Number

Insp. Stamp

Quality Control

Memo

0.00

10/05/26 D10-5-24

Dart	Aeros	pace	Ltd
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W/O:			WC	RK ORDER CHAN	GES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDE	R NON-CONFORM	IANCE (NC	R).			
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval
		Section A	Initial Action Description Chief Eng Chief Eng		Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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	1 1								•

Picklist Print

Tuesday, May 18, 2010 10:17:16 AM

Work Order ID: 58745

Parent Item:

D4016-1

Parent Item Name:

Hinge Half, Base

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD

as per dwg REV.A DD 10.02.22 verified by:EC

Start Date: 5/18/2010

Required Date: 5/31/2010

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name

Item ID M304B1.500X1.500

Replacement Mfg/ Purch Purchased Bin Primary Item Location No

Last Location

Route Seq ID 100

Unit of Measure

Qty on Hand 11.9002 0.08

Qty per Kit Qty Issued Date Issued

Status

Page 1

304 bar 1.50 X1.50

Location

MAT54

Loc Qty 11.90020368 11.2421

108381 112752 0.65810368 Loc Code

175 ml 10/05/22

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Dort No.		DAD #							_	
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DATE	STEP	Description of NC		Corrective Action Se Action Description	ection B		Verifica	ation	Approval	Approval
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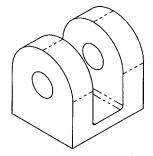
DART AEROSPACE LTD	Work Order: 53745
Description: Bashet Linge	Part Number: \\\(\sqrt{6} - \)
Inspection Dwg: 40 / 6 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

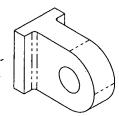
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		omments
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Date:	10/05/25	Date:	10/05/23			Date:	N/A
Rev Date	Change New Issue		• /	121		evised by	Approved

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY

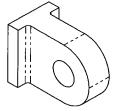
SUBJECT TO AMENDMENT WITHOUT NOTICE



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

RELEASE 2010 -02- 1 6

Α	NEW IS	SUE		JPH	10.01.29		
REV.			DESCRIPTION	BY	DATE		
DESIG	N	AJS	DART AEROS	PACEL	מז		
DRAW	N	AJS	HAWKESBURY, ON				
CHECK	(ED	00	DRAWING NO.		REV. A		
MFG. A	PPR.	7	D4016		SHEET 1 OF 2		
APPRO	OVED	140	TITLE		SCALE		
DE AP	PR.	4	BASKET HINGE		NTS		
DATE	10.0	1.29	COPYRIGHT © 2010 BY O/ thes document is prevate and confidential and its aut to be used for any purpose on cores on co weight prevate and and	WPPLED ON THE EXPRES	S CONDITION THAT IT IS		

Dart Aerospace Ltd	Darl	t Aerosp	ace	Ltd
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CHANGE			Ву	Date (Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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NCR:				ER NON-CONF									
DATE	STEP	Description of NC	Corrective Action Section B			Sign &	Verificati	ion	Approval	Approval			
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D GRAIN DIRECTION 0.88 0.13 0.250 0.50 0.875 R0.03 0.38+0.03 - 0.13 R0.38 Ø0.257 THRU R0.31 - 0.563 -REF GRAIN DIRECTION 0.88 0.63 0.50 Ø0.257 THRU 0.13 R0.03 TYP 0.75 D4016-3 HINGE HALF, LID **D4016-1 HINGE HALF, BASE D4016-5 HINGE HALF, LIGHT LID** NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B -5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B DESIGN DART AEROSPACE LTD DRAWN 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX AJS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4016 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE 6) IDENTIFICATION: NONE 7) WEIGHT -1: 0.09 lbs -3: 0.04 lbs -5: 0.01 lbs SCALE **BASKET HINGE** DE APPR.

8

5

DATE

10.01.29

NTS

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DATE	STEP	Description of NC	Initial	Action Description	B Sign	Verification C		
DATE	STEP	Description of NC	Initial	Action Description	B Sign	Verification C		
DATE	STEP	Description of NC	Initial	Action Description	B Sign	Verification C		